

Work Order ID 67144

Wednesday, March 09, 2011 12:47:40 PM



Page 1

Item ID: D3589-5

Accept



Setup Start



Revision ID:

Item Name: LATCH GUIDE

Stop



Start Date: 3/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA755 & DWG D3589

FOLIO REV: *R*

DWG REV: *R*

2-DEBURR AS REQUIRED

10/31/4

4 *0*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/4/4

4 *0*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67144

Wednesday, March 09, 2011 12:47:40 PM

Page 2

Item ID: D3589-5

Accept

Revision ID:

Item Name: LATCH GUIDE

Start Date: 3/9/2011 Start Qty: 4.00

Required Date: 3/16/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/04

4

0

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

11/4/04

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/05

MF

11-04-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:47:51 PM

Page 1

Work Order ID: 67144

Parent Item: D3589-5

Parent Item Name: LATCH GUIDE



Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.500W.049

Purchased

No

100

f

139.0546

0.26

1.094737



304 RD Tube .500 x .049W

11/4/4

Location

Loc Qty

Loc Code

MAT

135.2215878

114676

11.9789478

115010

123.24264

MAT017

3.833

111814

3.833

1.124

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

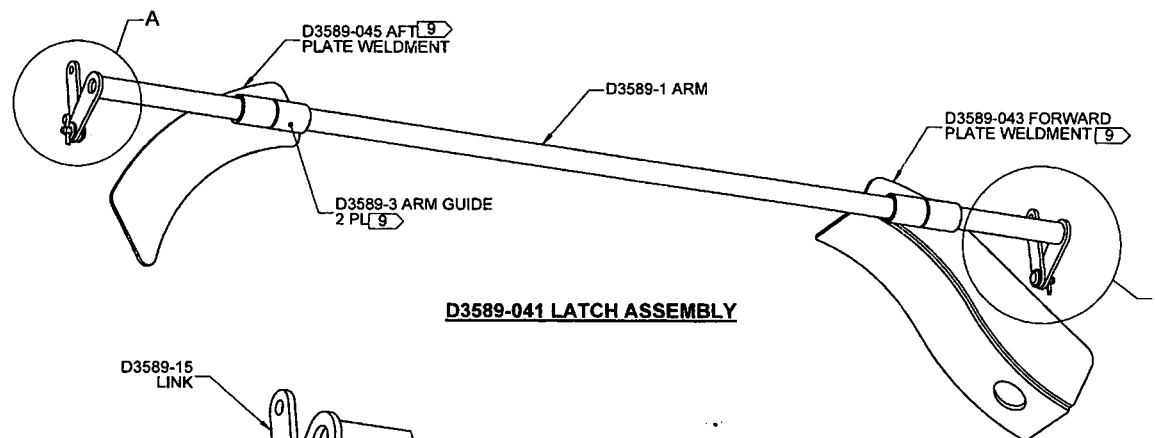
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

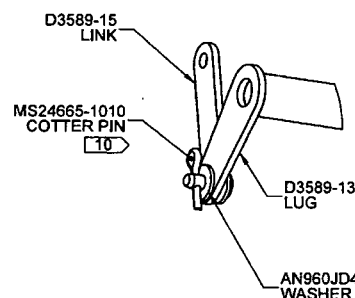
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

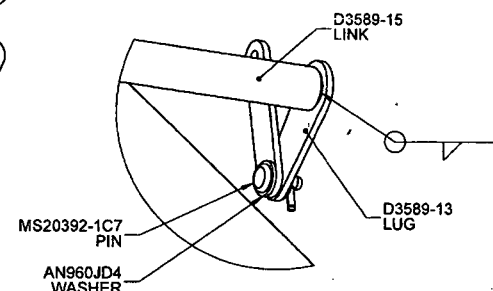


D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL

SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**

SCALE 2X
2 PL

RELEASED
09/26/05/11/14

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 0-71414

011-03-9

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 2.9 WAS 1.51 (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3589

REV. B
SHEET 1 OF 8

TITLE
LATCH ASSEMBLY

SCALE
NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

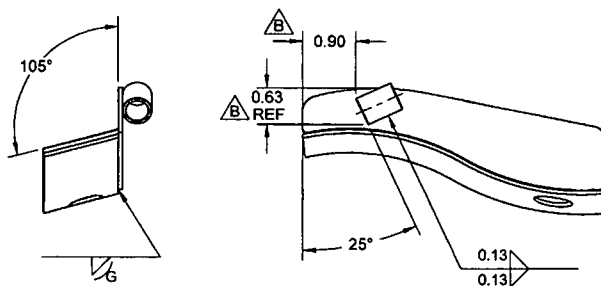
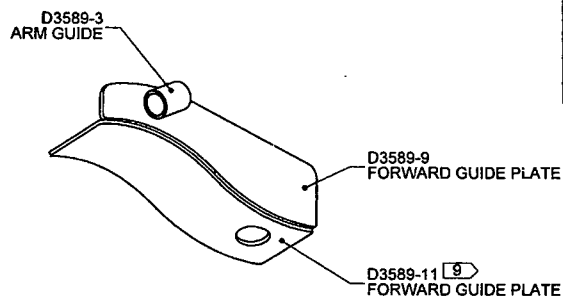
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

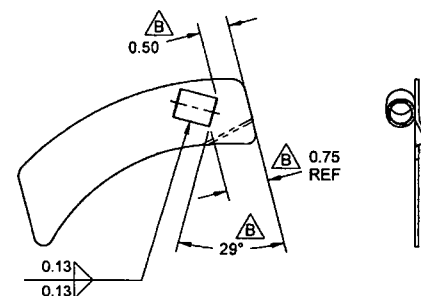
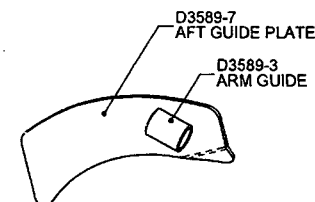
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

w/o 67144

RELEASED
09/03/05 N/A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

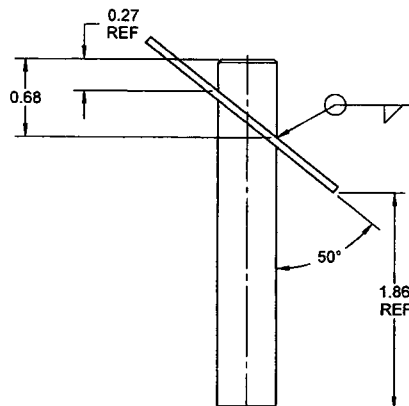
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE

D3589-17
FORWARD GUIDE PLATE

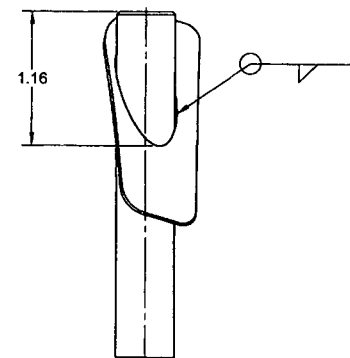
D3589-5
LATCH GUIDE



D3589-047 FORWARD GUIDE

D3589-19
AFT GUIDE PLATE

D3589-5
LATCH GUIDE



D3589-049 AFT GUIDE

u/o 67144

D3589-047/-049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3589
MFG. APPR.		REV. B SHEET 3 OF 8
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9/26/14

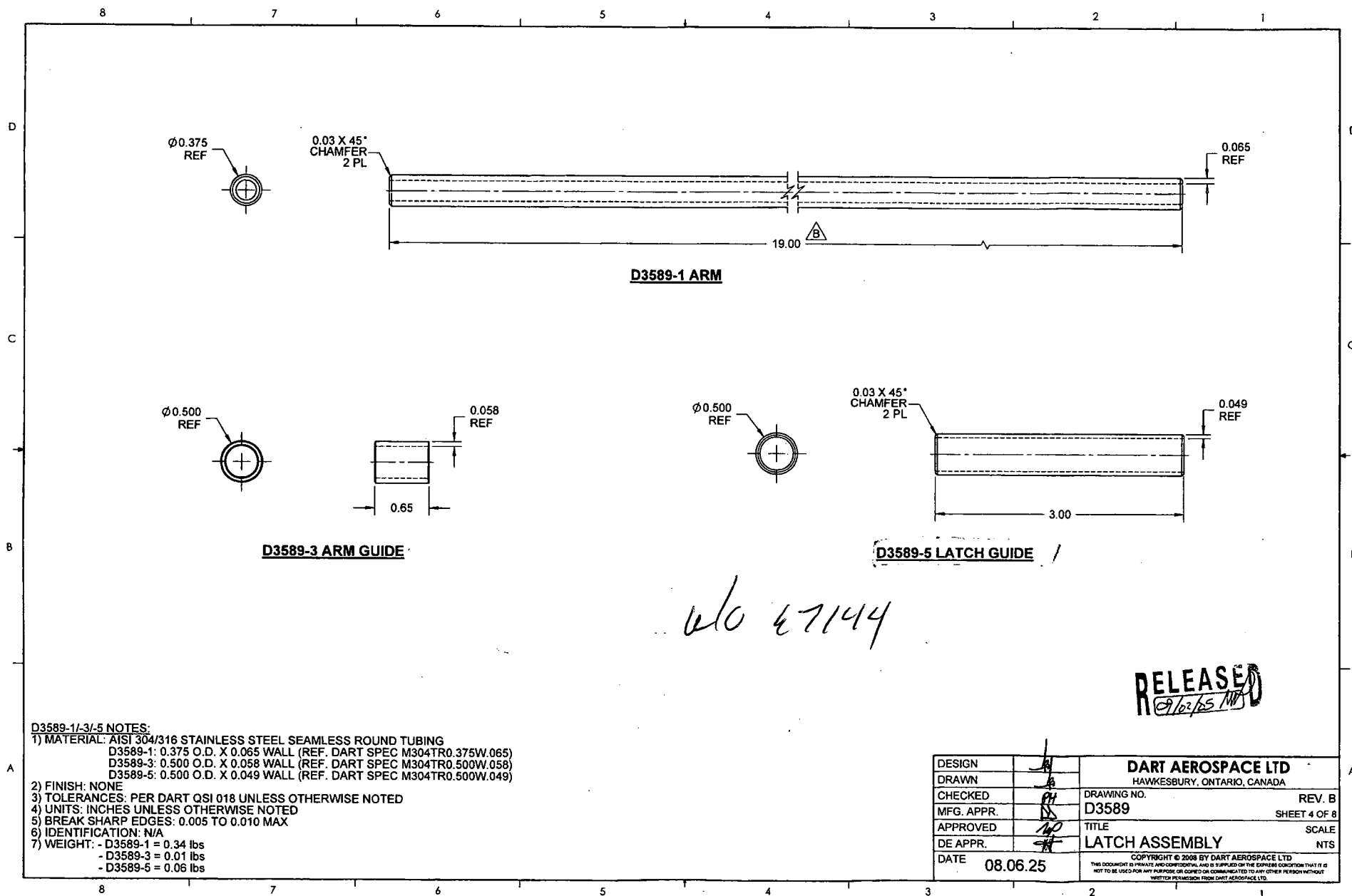
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 - D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 - D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 - D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

DESIGN	JH	DART AEROSPACE LTD	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	DRAWING NO.	REV. B
MFG. APPR.	JH	D3589	SHEET 4 OF 8
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DE APPR.	JH	LATCH ASSEMBLY	NTS
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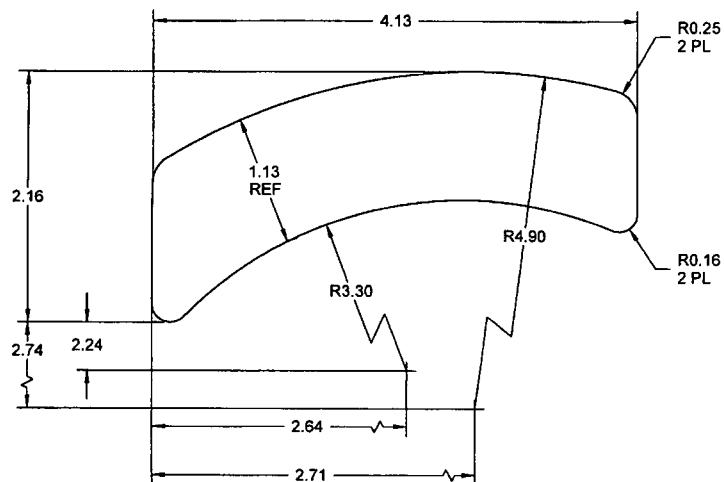
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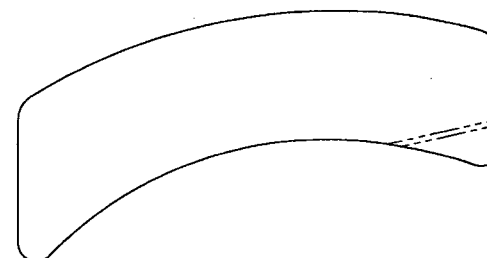
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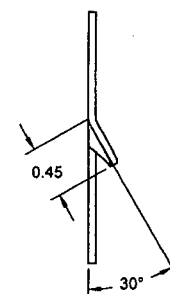
NOTE: Date & initial all entries



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**



u60 67144

RELEASED
09/12/15

D3589-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3589	REV. B
MFG. APPR.	<i>18</i>		SHEET 5 OF 8
APPROVED	<i>10</i>	TITLE LATCH ASSEMBLY	SCALE
DE APPR.	<i>11</i>		NTS
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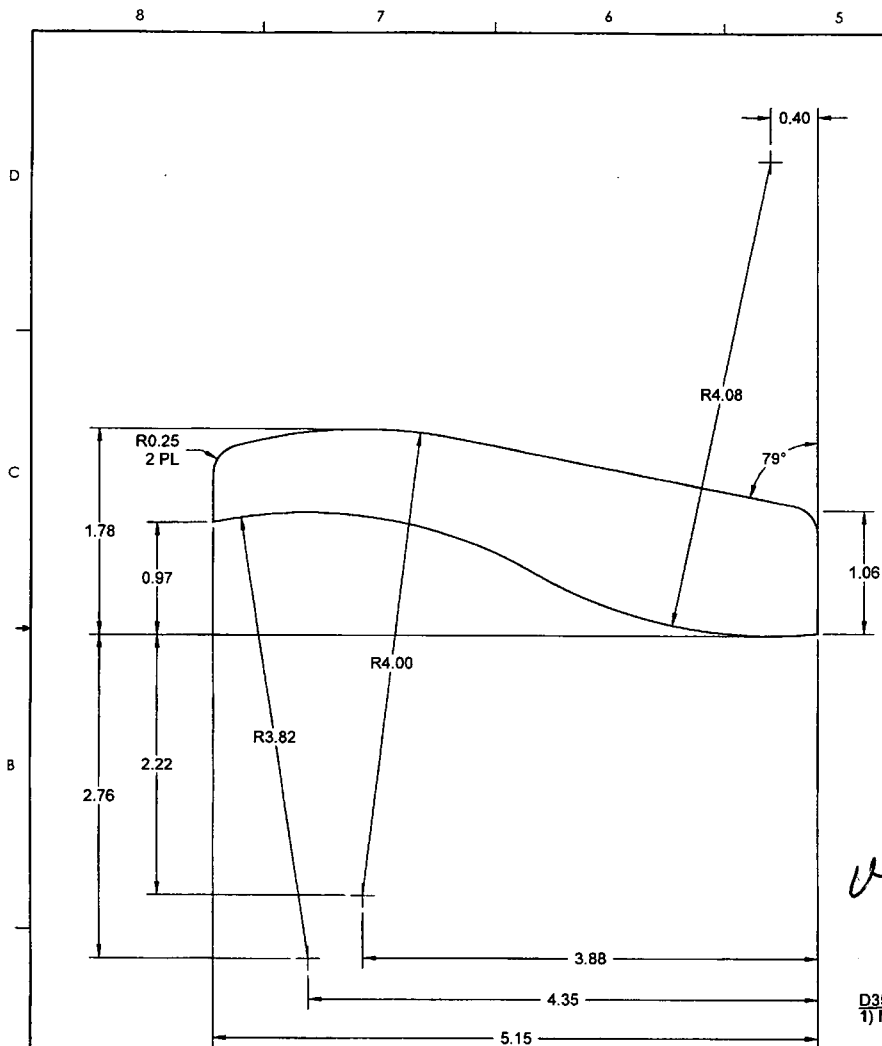
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

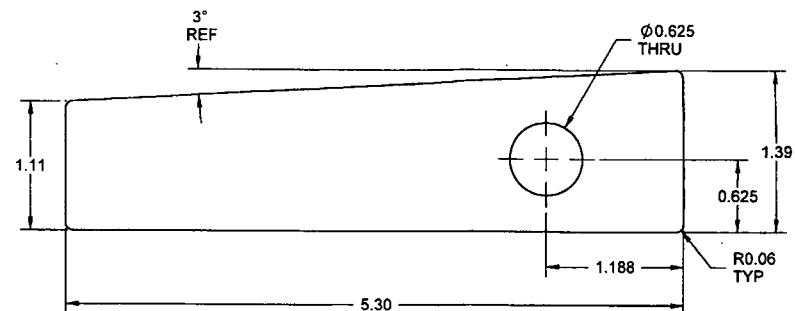
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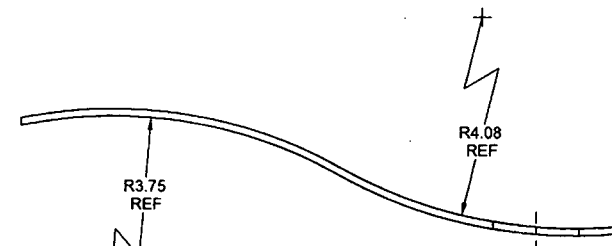
NOTE: Date & initial all entries



D3589-9 FORWARD GUIDE PLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN







D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

D3589-9/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
PER AMS 5513 OR AMS 5524,
OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK),
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

RELEASED
9/2/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
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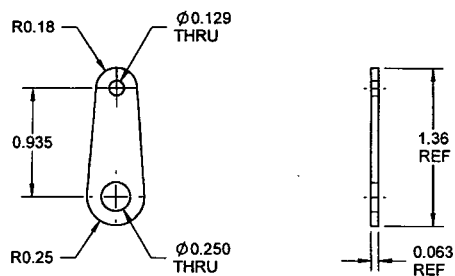
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

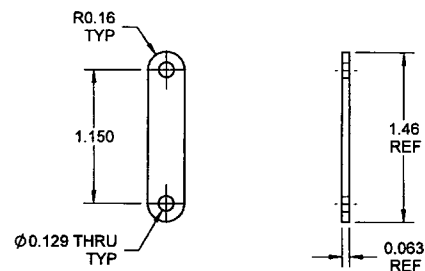
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-13 LUG



D3589-15 LINK

W/O 47144

RELEASED
09/02/05 1177

D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3589 REV. B
MFG. APPR.		SHEET 7 OF 8
APPROVED		TITLE LATCH ASSEMBLY SCALE
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

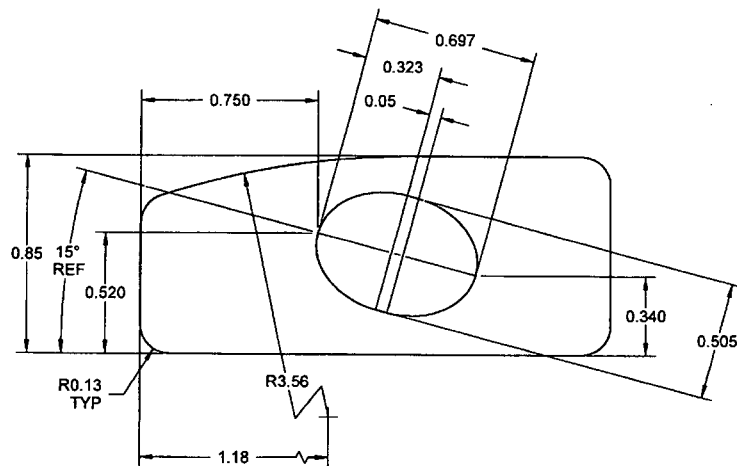
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D

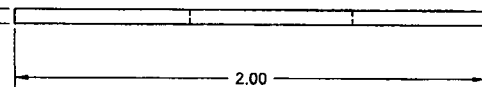
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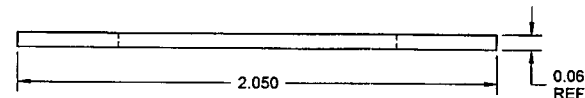
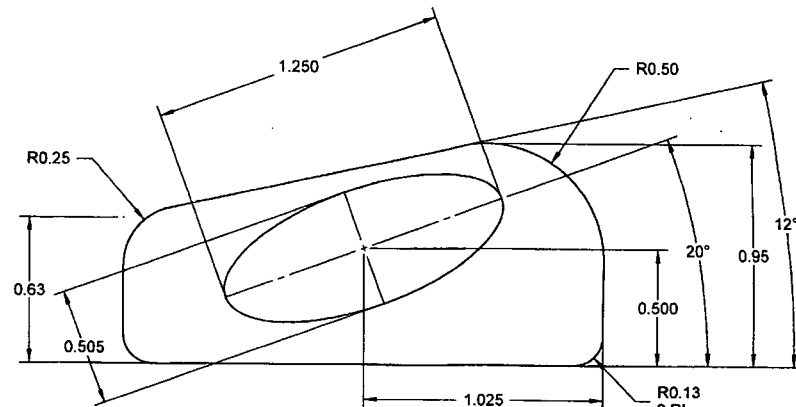
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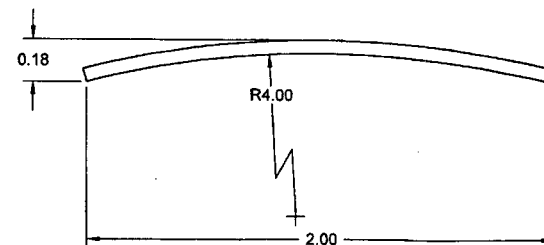
0.063
REF



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
09/02/05/11/17

D3589-17/-19/-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3589
MFG. APPR.		REV. B
APPROVED		SHEET 8 OF 8
DE APPR.		TITLE LATCH ASSEMBLY
DATE	08.06.25	SCALE NTS

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8 7 6 5 4 3 2 1

a/o 67144

W/O:		WORK ORDER CHANGES						
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